

Date: Monday, 23/03/2009 9:53:20 AM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-----------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 206 A/B HIGH GEAR WEB |
| Job Number : | 46637 | | |
| Estimate Number : | 10455 | | |
| P.O. Number : | | Part Number : | D26543 |
| This Issue : | 23/03/2009 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D2654 REV E1 |
| First Issue : | / / | Project Number : | N/A |
| Previous Run : | 45910 | Drawing Revision : | E1 |
| | Type : | Material : | |
| | SKIDTUBES | Due Date : | 30/03/2009 |
| Written By : | | Qty: | 2 |
| Checked & Approved By : | JULIA 03.23 | Um: | Each |
| Comment : | Est Rev:D 99.02.04 Fixed typo, Changed procedureDM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|-------------------------|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 1 | D2600-5 | Web | B38589 |

Handwritten: B38589 B38589 fm' 09-03-23 (2)

| | | |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

Handwritten: fm' 09-03-23 (2)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

Handwritten: RF 09-03-23 (2)

| | | |
|-----|-----------------|----------------------------|
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: fm' 09-03-23 (2)

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:53:20 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 46637

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u 9-3-23

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

PMC 09-03-23

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF
09-03-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

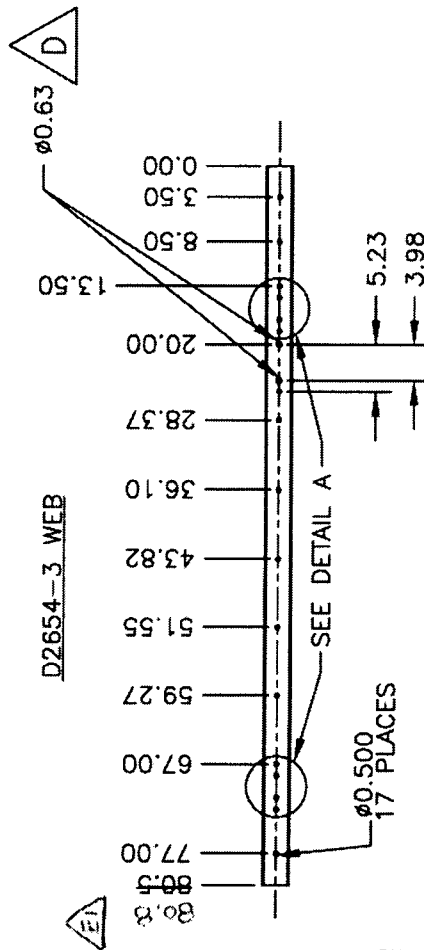
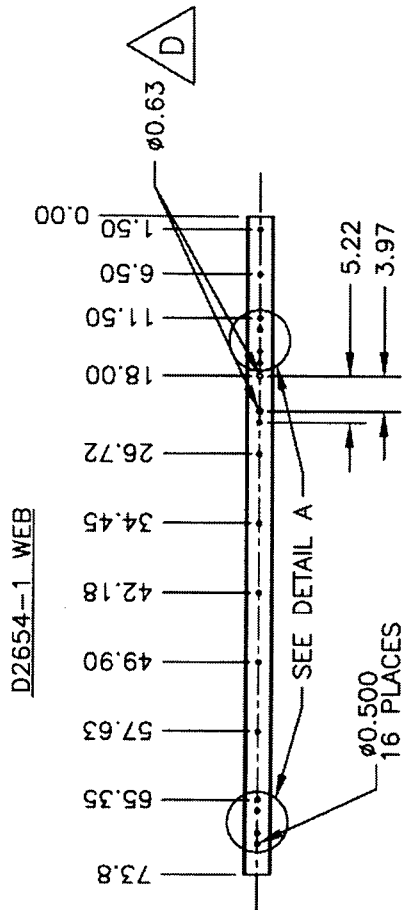
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------|----------|------------------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
| | | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| | | D2654 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 04.05.26 | | WEB | 1:20 |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.26 | ALTER HOLE PATRN., 0.500 WAS 0.438 | |
| C | 97.10.29 | CHANGED HOLE PATTERN | |
| D | 98.01.15 | GHW HOLES CHANGED TO $\phi 0.63$ | |
| E | 04.05.26 | CHANGE LENGTHS, REFORMAT | |
| E1 | 04.08.04 | PER TOOLING; B.P. WAS 89.5 | |

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04.06.22



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WORK ORDER
NO. 40037

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

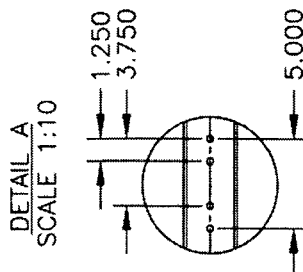
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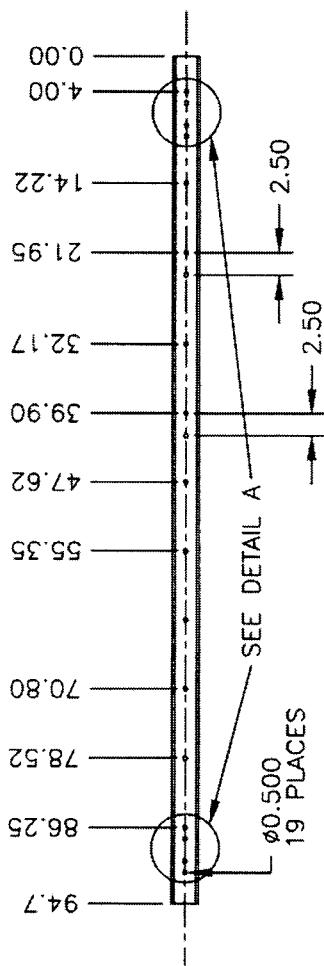


| | | | |
|------------------|----------------|--|------------------------|
| DESIGN IP | DRAWN BY IP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED H | APPROVED H | DRAWING NO. D2654 | REV. E SHEET 2 OF 2 |
| DATE 04.05.26 | | TITLE WEB | SCALE 1:20 |

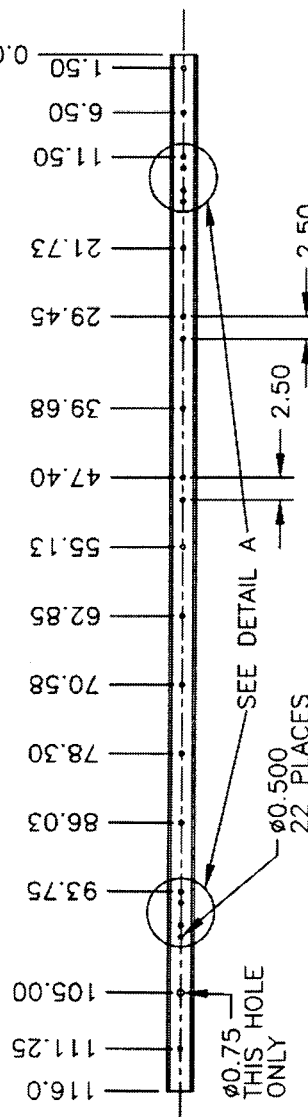
RELEASED
04.06.27



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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